

Work Order ID 81598

81598

March-16-12 8:35:04 AM

Page 1

Item ID: D3315-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate

Start Date: 15/03/2012 Start Qty: 5.00 ***5***

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 24/03/16 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3315	Rev B

100 0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3315 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

1010 1063

6 0 JM 12-6-24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

6 0 JM 12-6-24

120

QC8- Inspect parts - second check

0.00

120

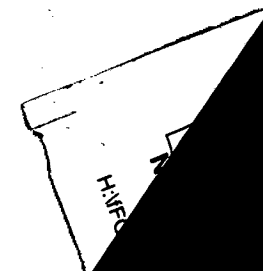
QC

Memo

0.00

Quality Control

6 0 W 12-6-25



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 29/03/2012 Req'd Qty: 5.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Small Fab

Small Fab

Memo

0.00

Small Fab

Debur if necessary

N/A

140

0.00

140

NC-BRAKE

Brake NC

Memo

0.00

Brake NC

1- Form using DT8751 Die as per Dwg D3315Rev: B 2- Form using
DT8179 Die and form joggle using DT8157 as per Dwg D3315Rev: B

150

0.00

150

QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

5/16/13

(76)

7

8/12/06/29

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 Required Date: 29/03/2012 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld hard surface using D3315-1T3 as per QSI 004 and Dwg D3315 Rev:								
	B Qty Part Number Description Batch A/R								
	N/A 7560 Hardcoat Rod m/22359								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									

⑩ me 12-08-15

DAS 16 12/8/15

DMB 12-8-15

DAS 16 12/8/15

6

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Powdercoat Powder Coating m121279	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 11:30 FINISH TIME: 12:00 OVEN TEMPERATURE: 3200F	0.00 0.00				6x			mt 12/08/16
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				6			BL 12820.
210 *210* Packaging Packaging	Packaging Memo Identify on inside surface using a permanent fine point marker with the following:TCCA-PDA, Dart Aerospace Ltd.P/N: D3315-1, B/N: BXXXXXFor Product Eligibility see PDA04-17and StockLocation: 560	0.00 0.00		50		6x			St 12/08/21

W/O:		WORK ORDER CHANGES					
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Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

MLJ 12/08/23

U1208, 24

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DART AEROSPACE LTD		Work Order:	81598
Description: Wearplate		Part Number:	D3315-1
Inspection Dwg: D3315	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.266 x 0.450	+0.006/-0.001 x +/-0.010	0.271 x 0.460	✓		✓	mmol
4.402	+/-0.010	4.401"	✓		✓	"
4.137	+/-0.010	4.129"	✓		✓	"
3.550	+/-0.010	3.558"	✓		✓	"
5.464	+/-0.010	5.461"	✓		✓	"
5.214	+/-0.010	5.206"	✓		✓	"
1.224	+/-0.010	1.221"	✓		✓	"
2.57	+/-0.030	2.583"	✓		✓	"
6.273	+/-0.010	6.271"	✓		✓	"
8.224	+/-0.010	8.220"	✓		✓	Prod WJoz
9.515	+/-0.010	9.515"	✓		✓	"
11.429	+/-0.010	11.424"	✓		MT	"
15.474	+/-0.010	15.474"	✓		MT	PB01
16.379	+/-0.010	16.379"	✓		MT	"
21.360	+/-0.010	21.360"	✓		MT	"
23.474	+/-0.010	23.474"	✓		MT	"
26.273	+/-0.010	26.273"	✓		MT	"
29.42	+/-0.030	29.42"	✓		MT	"
0.060	+/-0.010	0.058"	✓		✓	mmol
Ø0.300	+0.006/-0.001	0.303"	✓		✓	"

Measured by:	TM
Date:	12-6-24

Audited by:	MA
Date:	12-06-25

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.28	New Issue	KJ	MA

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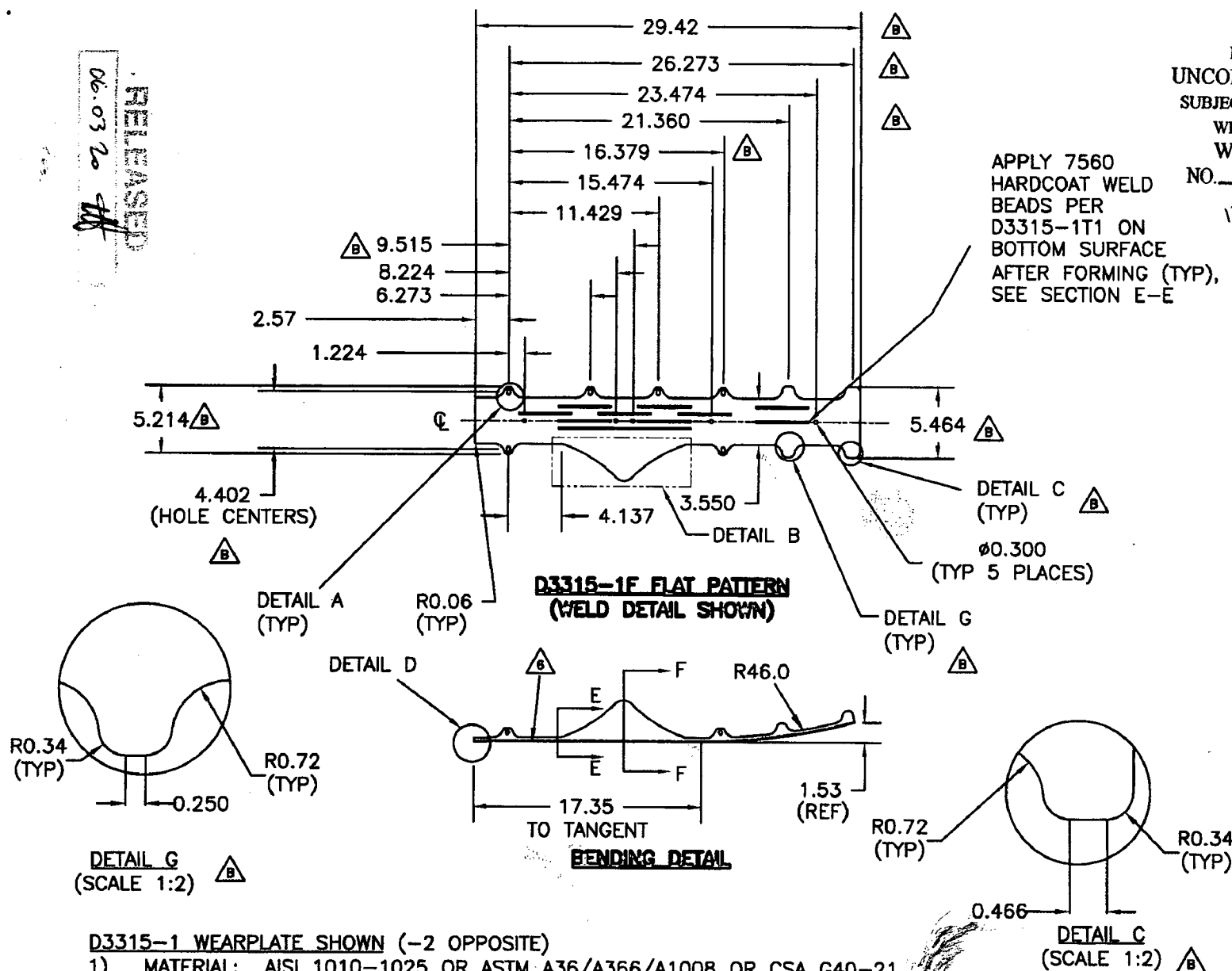
RELEASED
06.03.20

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 01598 MCT

12/03/16

DART

APPLY 7560
HARDCOAT WELD
BEADS PER
D3315-1T1 ON
BOTTOM SURFACE
AFTER FORMING (TYP),
SEE SECTION E-E



D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	DRAWN BY	DART AEROSPACE LTD
04	04	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
06.01.31	04.09.10	D3315
DATE	TITLE	SCALE
06.01.31	WEARPLATE	1:12
REVISION	DATE	DESCRIPTION
A	04.09.10	NEW ISSUE
B	06.01.31	UPDATE DIMENSIONS

REV. B
SHEET 1 OF 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

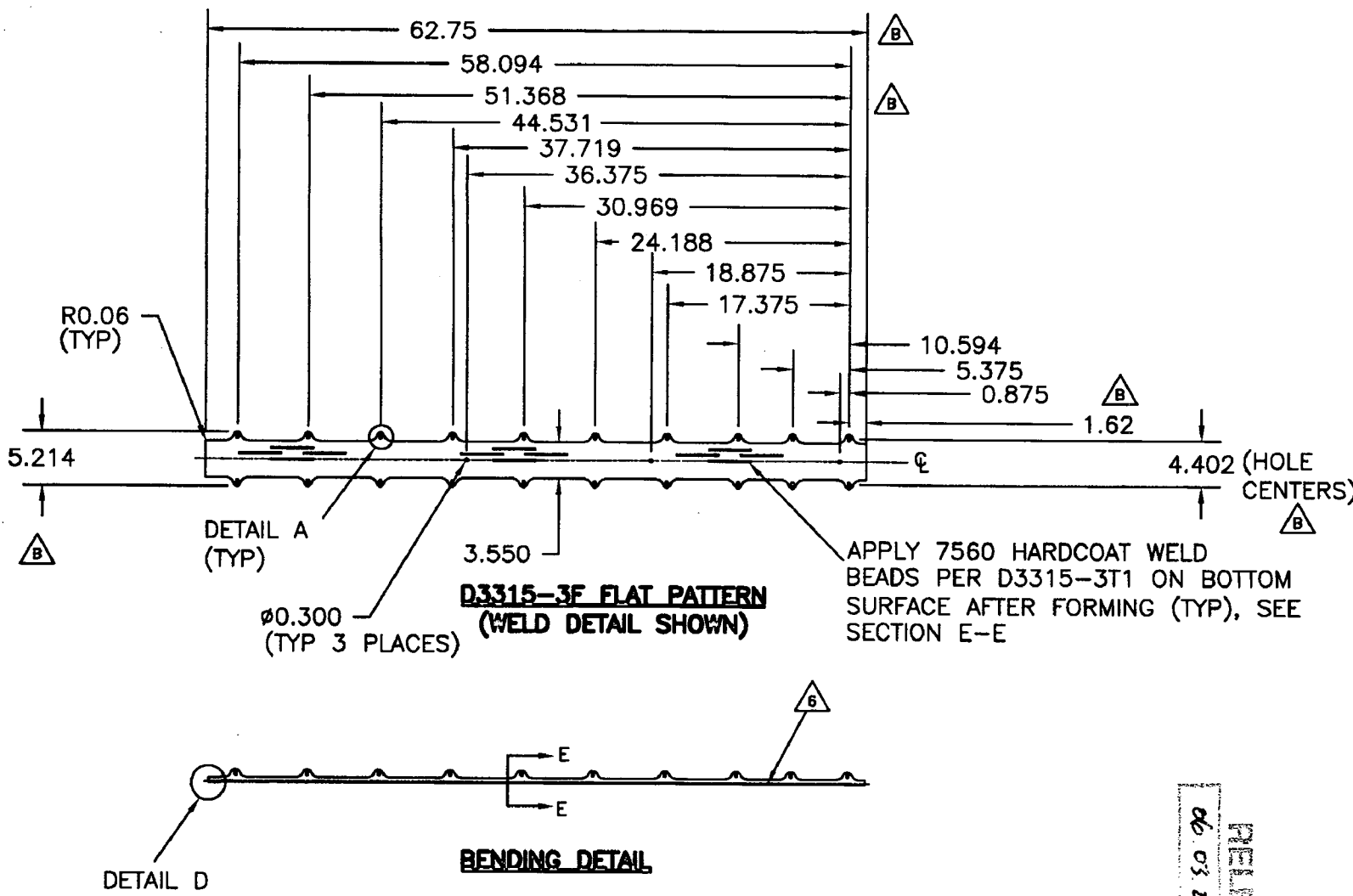
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

01598



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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.
DATE	06.01.31			D3315
				SHEET 2 OF 4
				SCALE
				1:16
				WEARPLATE



D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED
06.03.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

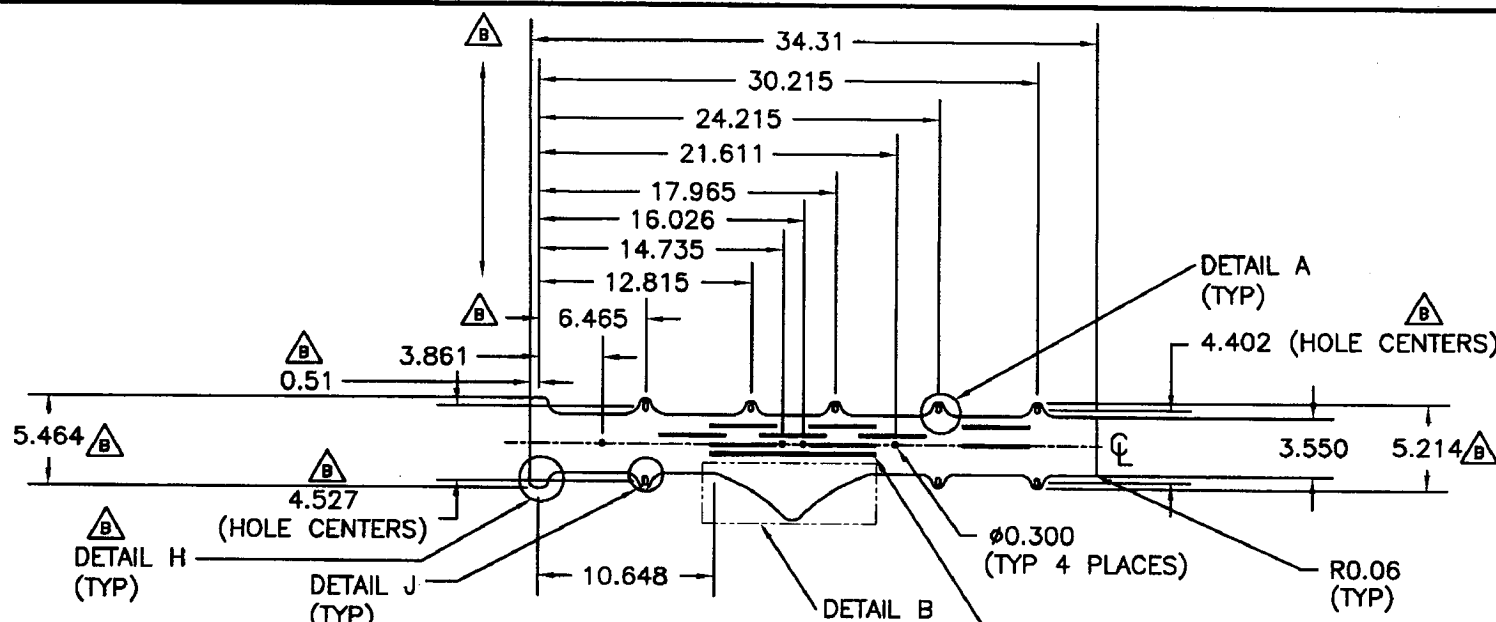
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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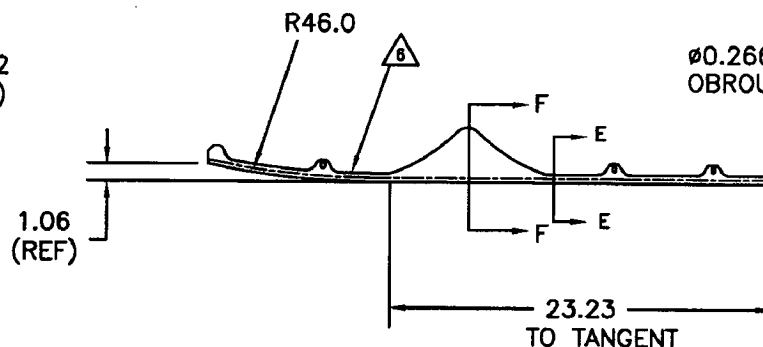
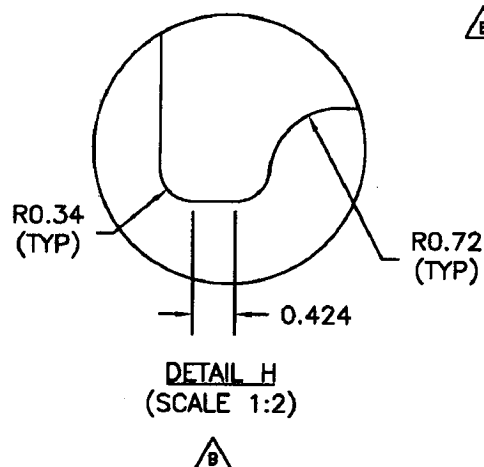
81598

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CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	DRAWING NO.	D3315	REV. B
TITLE	WEARPLATE	SHEET 3 OF 4		SCALE
				1:12

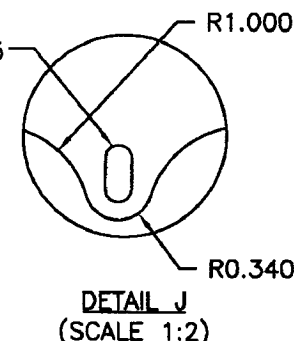


**D3315-5F FLAT PATTERN
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD
BEADS PER D3315-5T1 ON BOTTOM SURFACE
AFTER FORMING (TYP), SEE SECTION E-E



BENDING DETAIL



D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
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B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

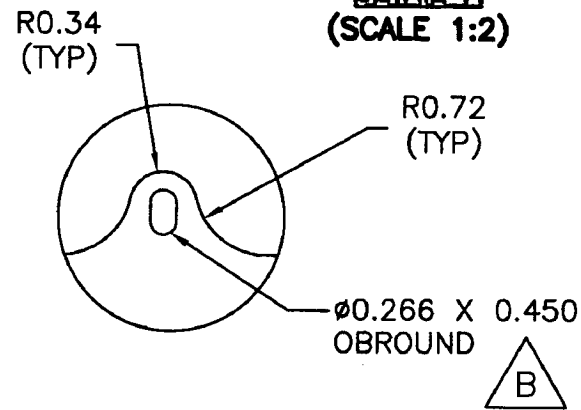
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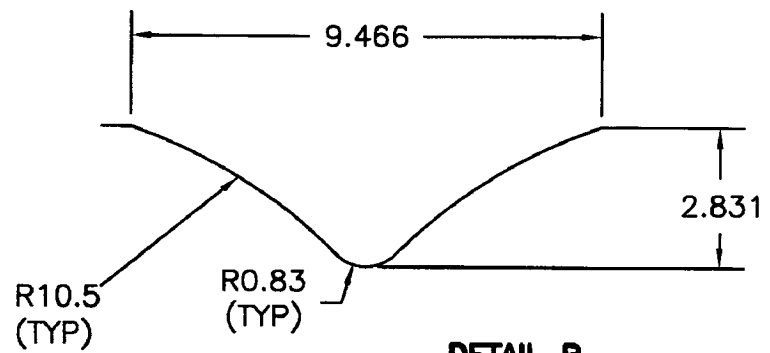


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DATE	06.01.31	TITLE	WEARPLATE	REV. B SHEET 4 OF 4
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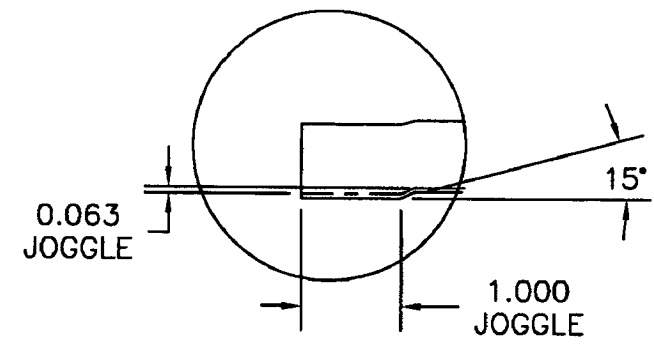
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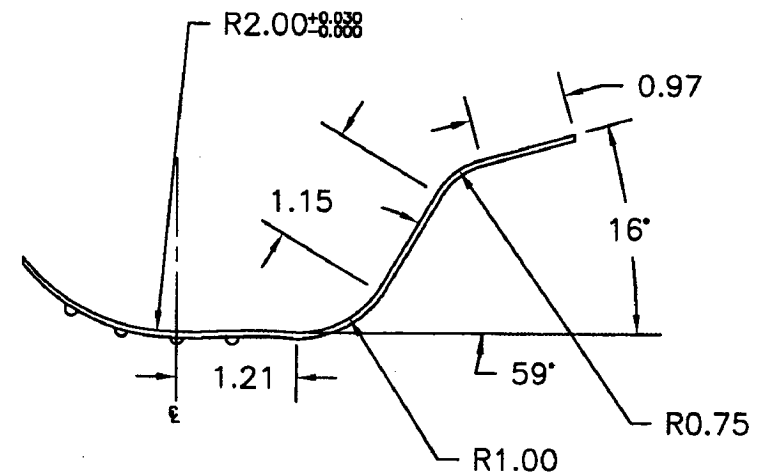
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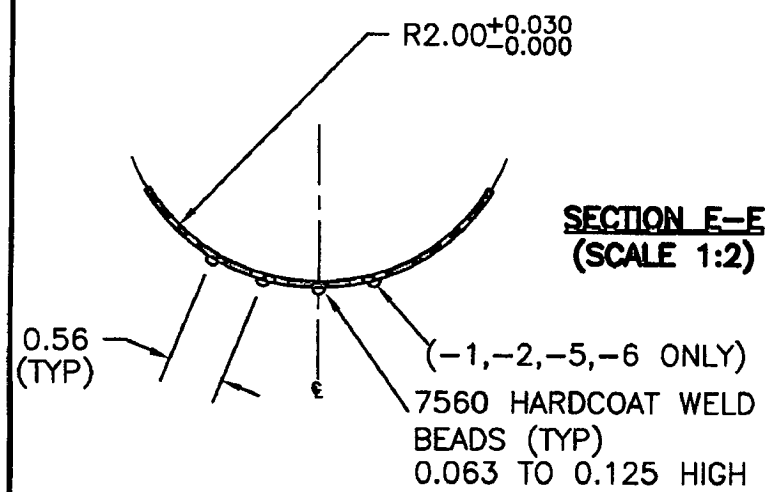
DETAIL D
(SCALE 1:2)



SECTION F-F
(SCALE 1:2)



SECTION E-E
(SCALE 1:2)



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06.03.20

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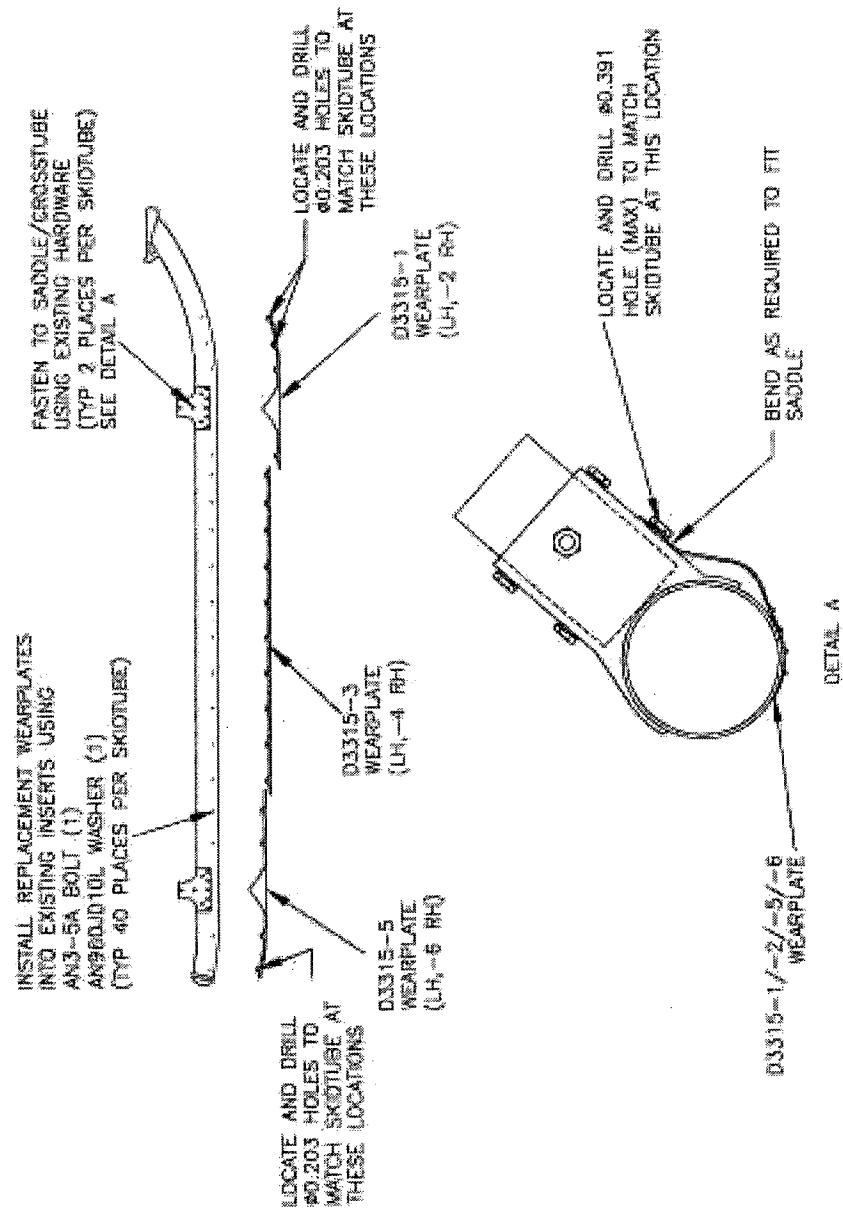
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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FIGURE 1: D412-726-111 WEARPLATE KIT
(205/212/412 STANDARD SKIDTUBE)
(LH SKIDTUBE SHOWN, VIEW LOOKING OUTBOARD)
(RH OPPOSITE)



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Revision: **B**

Date: 06.03.08